

Date: Friday, 8/10/2007 10:28:32 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 33867	
Estimate Number : 12788	
P.O. Number : N/A	Part Number : D356413
This Issue : 8/10/2007 S.O. No. : N/A	Drawing Number : D3564 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 33800	Material : N/A
Written By : <u>JLM/07-08-10</u>	Due Date : 8/17/2007
Checked & Approved By : _____	Qty: 50 Um: Each
Comment : Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1785 sf(s)/Unit Total : 8.9250 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: M105130

SAD 07/08/11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3564
Dwg Rev: C
Prog Rev: C

2-Deburr if necessary

SAD 07/08/12

SAD 07/08/11

55

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/11

55

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Ep 07/08/03

counted
155

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT 8157 and DT 8179

SAD 07/08/12

SB 07/08/19

55

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33867

Part Number: D356413

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

counter
En 21/02/19 (455)

7.0

POWDER COATING

POWDER COATING



M104846



(55x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-h 07/09/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FR 07/09/20 (55)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-16

W

07-09-20

(55)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(55)

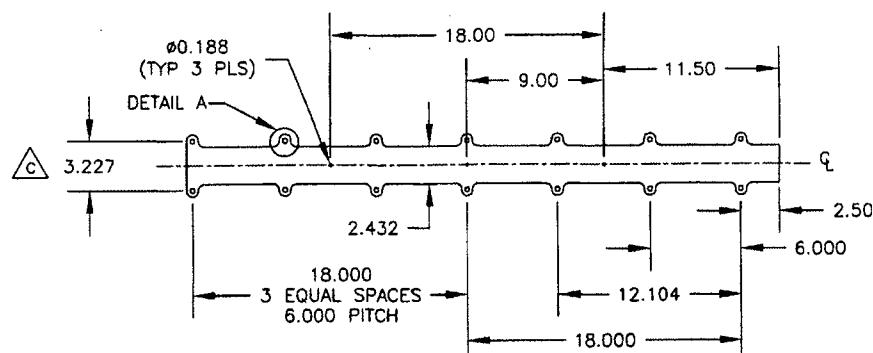
Comment: FINAL INSPECTION/W/O RELEASE

07/09/21

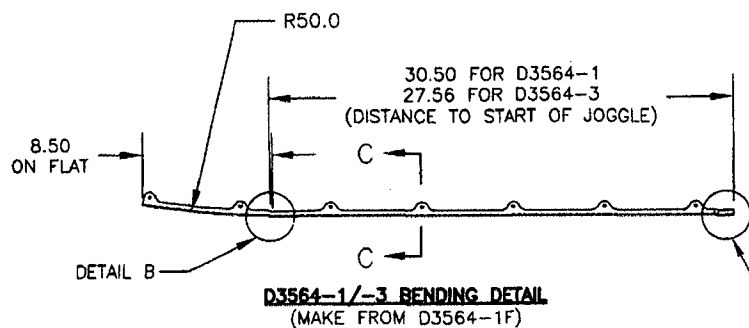
Job Completion



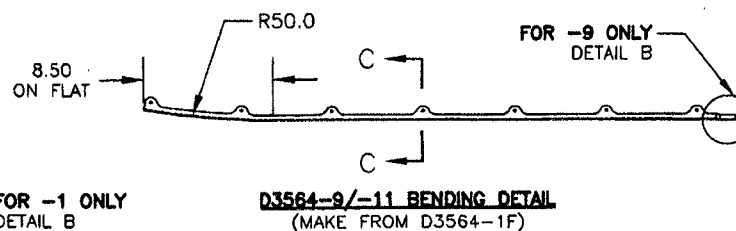
U 07-09-21



D3564-1F FLAT PATTERN

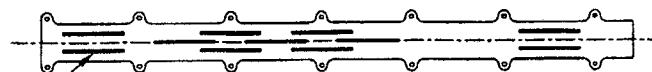


D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07.06.28

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

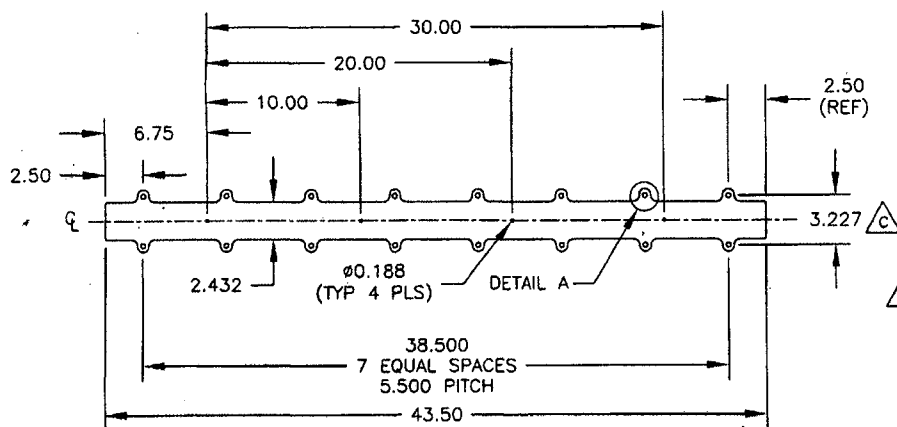
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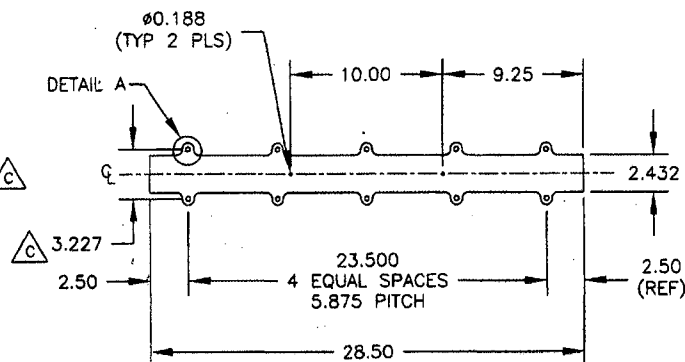
C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DH	DRAWN BY DH
CHECKED	#	APPROVED #
DATE	07.04.17	TITLE WEARSHOE
DRAWING NO.	D3564	REV. C
		SHEET 1 OF 2
		SCALE 1:8

DART

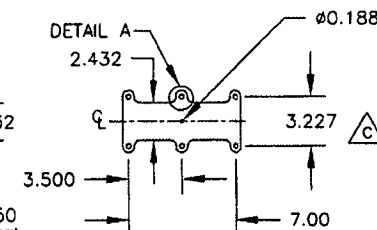
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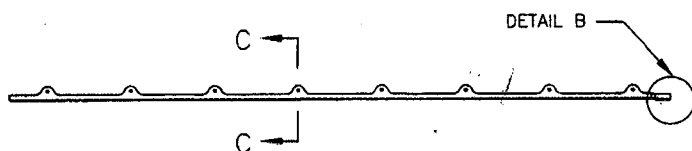
D3564-5F FLAT PATTERN



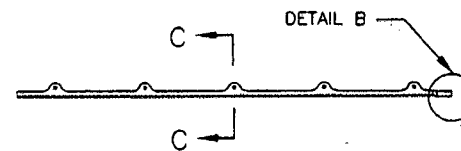
D3564-7F FLAT PATTERN



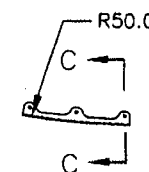
D3564-13F FLAT PATTERN



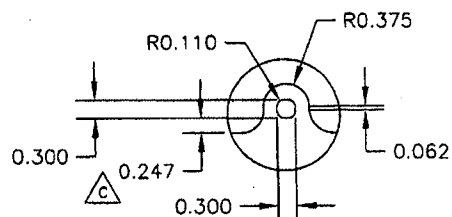
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



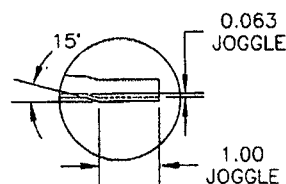
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.04.17

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DESIGN
CHECKED
DATE
07.04.17

DRAWN BY
APPROVED

DART
DRAWING NO.
D3564
TITLE
WEARSHOE

DART AEROSPACE LTD.
WARRICKS, ONTARIO, CANADA
REV. C
SHEET 2 OF 2
SCALE
1:8

